

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020955**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 008383.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG3014J-113, 108, 068, 073, 078, 083.
- 2) SEG3014C- 093, 094, 098, 097, 101, 102.

This QA Inspector observed the following work in progress:

West Grillage:

This QA Inspector observed ABF personnel doing UT of Grillage welds after completion of repair welding. 2 nos

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of welds are marked again for repair (weld joint nos: SA7512C-257 and 258). ZPMC QC was identified as Shen Jian Bo.

OBG Seg 13AW:

The Shielded Metal Arc welding (SMAW) process on weld joint no: Seg3013B-262 [Vertical Plate (VP) 3010A to Floor Beam (FB) 3199A, complete joint penetration (CJP) weld at Panel Point (PP) 120. The welder is identified as 045196 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013M-014 [FB3180 to Deck Panel (DP) diaphragm (of DP3123A), CJP weld at PP118.35]. The welder is identified as 201583 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

This QA Inspector observed ZPMC personnel performing Magnetic Particle testing (MT) on weld nos: Seg3013L-006 [FB3185A to Longitudinal Diaphragm (LD) 3031A and Seg3013K-004 (FB3185A to LD3034A) at PP119-1500. 1 no of location on each weld was identified for MT repair. UT of these welds by CT is already completed. This QA Inspector informed about this issue to ABF QA identified as Wei Jian Bo and ZPMC QC identified as Liu Feng. ZPMC QC agreed that they will perform repair welding after having Critical Welding Repair (CWR) for these welds.

OBG Seg 14W:

The SMAW process on weld joint no: DP3172-017 (DP to DP diaphragm, CJP weld]. The welder is identified as 037779 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
